



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D350-636-016
Job Sheet 167339-A



Part No: D350-636-016

Job Qty: 1 ea

Part Name: Skidtube RH, Run-on Landing Wearplates, DART(Apical) Cylind./Aerazur Float Comp.



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/27/17

Job Tracking No:

Due Date: 11/24/17

Created By: Mario Poulin

Type: Stock

Description:

Customer: Air Methods Corporation (CAMET01)

7301 South Peoria Street Englewood, CO, 80112 USA ph:(303) 792-7400

Ship Via:

PM A

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		11/23/17	0.00	0.00	Start Up Skidtubes		
110	Skidtubes	1 pcs		11/23/17	0.00	4.78	Skidtubes		<i>MEH BE</i>
120	QC	1 pcs		11/23/17	0.00	0.00	QC10		<i>18-01-11</i>
130	QC	1 pcs		11/23/17	0.00	0.00	QC5		<i>18-1-11</i>
140	HandFinish	1 pcs		11/23/17	0.00	0.98	HandFinish1		<i>AP 18-1-12</i>
150	QC	1 pcs		11/23/17	0.00	0.00	QC7		<i>BE 18-01-15</i>
160	Skidtubes	1 pcs		11/23/17	0.00	4.78	Skidtubes		<i>MEH BE MEH</i>
170	QC	1 pcs		11/23/17	0.00	0.00	QC10		<i>3-88</i>
180	QC	1 pcs		11/23/17	0.00	0.00	QC5		<i>3-88</i>
190	HandFinish	1 pcs		11/23/17	0.00	0.98	HandFinish2		<i>2018/01/22 JSC</i>
200	SprayPaint	1 pcs		11/23/17	0.00	0.61	Spray Paint		<i>DI 18-01-30</i>
210	QC	1 pcs		11/23/17	0.00	0.00	QC14		<i>BE 18-02-01</i>
230	HandFinish	1 pcs		11/24/17	0.00	0.98	HandFinish4		<i>BE 18-02-01</i>
240	QC	1 pcs		11/24/17	0.00	0.00	QC5		<i>38</i>
250	Packaging	1 pcs		11/24/17	0.00	0.00	Packaging1		<i>9-88</i>
260	QC	1 pcs		11/24/17	0.00	0.00	QC4		<i>FEB 6 2018</i>
265	DC	1 pcs		11/24/17	0.00	0.00	DC		<i>18-01</i>
270	Packaging	1 pcs		11/24/17	0.00	0.00	Packaging3		<i>18-01</i>
280	QC21-FG	1 Ea		11/24/17	0.00	0.00	QC21		<i>FEB 18 2018</i>

Part Op 110 - 1- Pick D2600-3 Bent 4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting, section R-R
Descriptions: and open to 0.500" 6- Drill most FWD wearplate hole using DT9678 locating of 66.54" hole 7- Open up holes of Detail J to 0.297" (total of 2 holes per side) + .201" (total of one hole per side) as per dwg D4168.

160 - 1-Open up holes using hole saw of Detail L and ground handling to 0.625" (total of 8 holes per side) 2-Open up holes using hole saw of Detail K to 0.750" (total of 4 holes per side) 3- Open float hole to 0.500" using uni-bit (4 per side) and Run on wearplate holes to .375" 4 per side 4-Chamfer holes of Detail K,L, ground handling and float holes per dwg D4168 (welding instructions on sheet 9) 8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D4168 & QSI004 11- Spot face ground handling holes section (total of 4 places per side) as per dwg D4168 12- C'bore section CH-CH. ADJUST TOOLING AS REQUIRED. 13- Deburr holes, ensure tube is free of all scratches before sending to paint.

***** FOR DELUXE SKIDTUBE IF APPLICABLE DRILL TOW RING HOLE IN TUBE *****REF TO W/O BATCH: *****

180 - ***VERIFY C'BOARD IS GOOD***

190 - Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

200 - 1- PRIME AS PER DWG AND QSI 005 4.2 Primer: 137670 White paint: 138686

210 - Inspect for foreign object per QSI 024

230 - 1- Install inserts as per Dwg D4168

SikaFlex: m138654

EXP: 18-04-21

000473

DART
AEROSPACE
S031404

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA

TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



**Skidtube RH, Run – on Landing Wearplates, DART(Apical)
Cylind./Aerazur Float Comp.**

PART NO: D350 – 636 – 016

Revision:

Operation: Start up Operation

Change No: CHG005

Mfg Date: 01/11/18

Job No: 167339 – A

250 - If making a D350-636-216

260 - *****ensure antiseize is on AN8C21A bolts*****

265 - record fwd angle: 89.8 Photocopy blue file and type labels per PPP D350-636-016 CHG 005

270 - Identify and pack for shipping as per PPPD350-636-016 Location : FG071

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D2600-3-BENT-RH- <u>5630354</u>	1	0	0	0
	D2744 <u>5003318</u>	1	0	0	0
160-Skidtubes	D2739 <u>B165489</u>	1	15	0	0
	D2743 <u>B160400</u>	8	145	0	0
	D3490-1 <u>F165397</u>	4	33	0	0
	D3490-3 <u>5030870</u>	4	20	0	0
	ALS4-1032-225 <u>FM135998-2</u>	4	897	0	0
230-HandFinish	AN3C34A <u>8000840</u>	1	19	0	0
	AN3C36A <u>FM132381</u>	4	586	0	0
	XAN3C37A	1	68	0	0
	XAN3C42A	1	60	0	0
	AN3C6A <u>5019397</u>	4	88	0	0
	AN6C44A <u>FM137055-1</u>	4	251	0	0
	AN8C35A <u>FM137203</u>	1	99	0	0
	D2745 <u>5000380</u>	8	92	0	0
	D3488-042 <u>F163297-2</u>	1	5	0	0
	D3492-1 <u>5025647</u>	8	59	0	0
	D3492-3 <u>F165369 x5</u>	8	101	0	0
	D3631-15008168	8	4	0	0
	D3873-1 <u>5001354</u>	7	171	0	0
	D4154-041 <u>F163461</u>	1	7	0	0
	D4170-1 <u>B1641069</u>	4	22	0	0
	D4171-1 <u>F153784</u>	1	13	0	0
	MS21043-3 <u>FM136182-40</u>	5	829	0	0
	MS21043-6 <u>5016883</u>	4	66	0	0
	MS21083C8 <u>5034401</u>	1	7	0	0
	NAS1149C0332R <u>5019380-1</u>	4	4,758	0	0
	NAS1149C0363R <u>5017102</u>	9	221	0	0
	NAS1149C0832R <u>FM135536-0</u>	1	118	0	0
	NAS1515H3L <u>FM137361-25</u>	4	222	0	0
	NAS1611-010 <u>FM138441-2</u>	8	123	0	0
	NAS1611-013 <u>5022089</u>	8	117	0	0
250-Packaging	AN8C21A	2	239	0	0
	D2741	1	70	0	0
	D3493-1	2	42	0	0
	MS21083C8	2	7	0	0
	NAS1149D0863J	2	209	0	0

Part Specifications

Specifications could not be found.

Plex 10/27/17 2:56 PM dart.poulin.mario

ST 348
ST 083

000345

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D4168-041	350 SKIDTUBE ASSEMBLY, LH
	X			D4168-042	350 SKIDTUBE ASSEMBLY, RH
		X		D4168-043	350 SKIDTUBE ASSEMBLY, LH
			X	D4168-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
8	8	8	8	D3631-1	WASHER
7	7	7	7	D3873-1	BUSHING
1	1	1	1	D4154-041	WEARPLATE ASSEMBLY
1				D4168-1	SKIDTUBE WELDMENT, LH
	1			D4168-2	SKIDTUBE WELDMENT, RH
		1		D4168-3	SKIDTUBE WELDMENT, LH
			1	D4168-4	SKIDTUBE WELDMENT, RH
4	4	4	4	D4170-1	SPACER
1	1	1	1	D4171-1	BUSHING
4	4	4	4	ALS4-1032-225	INSERT
4	4	4	4	AN3C8A	BOLT
1	1	1	1	AN3C34A	BOLT
4	4	4	4	AN3C38A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN6C35A	BOLT
9	9	9	9	AN960C10	WASHER (OR NAS1149CO363R)
4	4	4	4	AN960C10L	WASHER (OR NAS1149CO332R)
1	1	1	1	AN960CB16L	WASHER (OR NAS1149CO832R)
5	5	5	5	MS21043-3	NUT
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

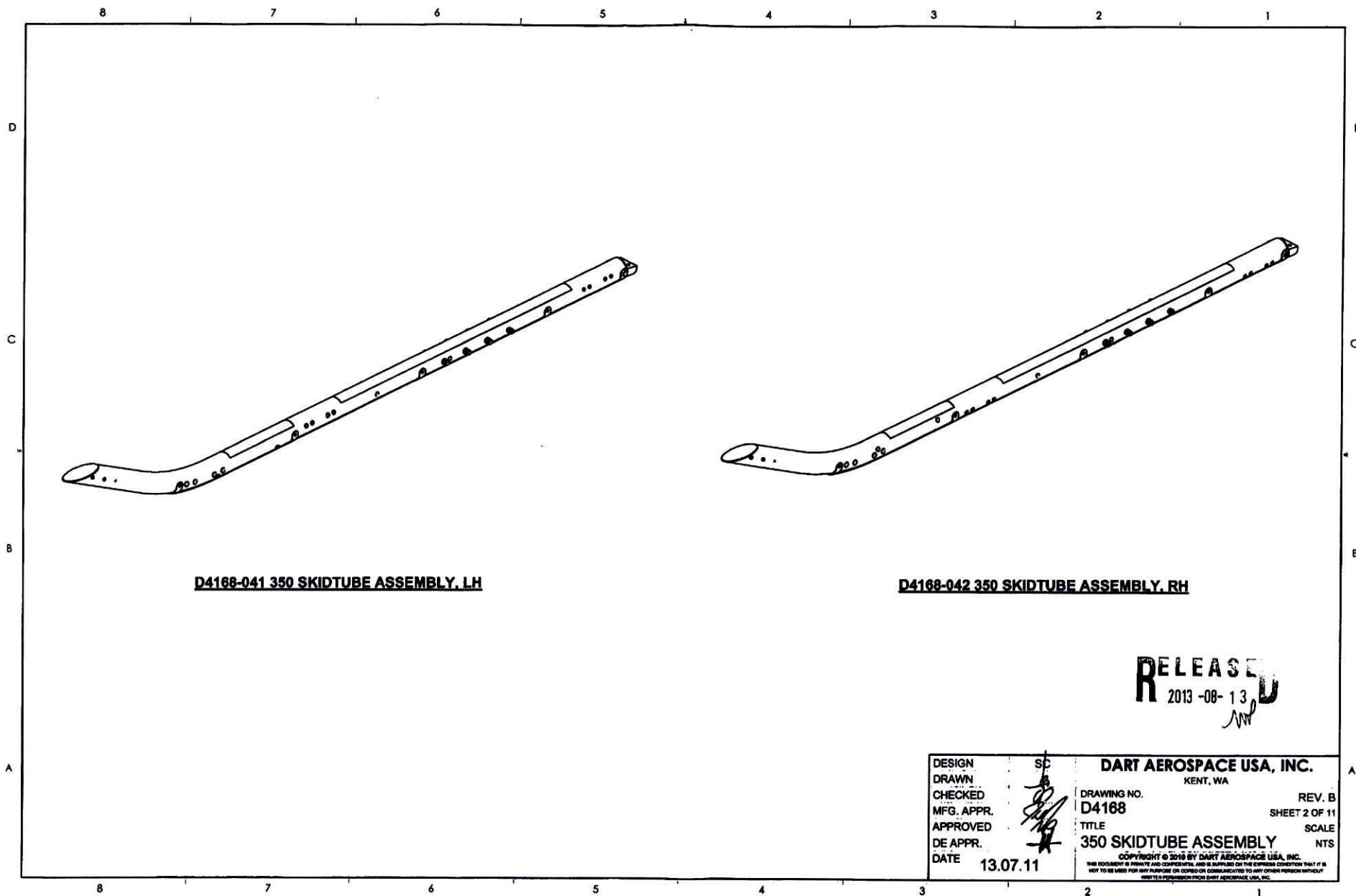
- MATERIAL: MAKE D4168-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D4168-041/-042/-043/-044 = 32.3 LBS
- WELD PER DART QSI 004
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF
FINISH WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

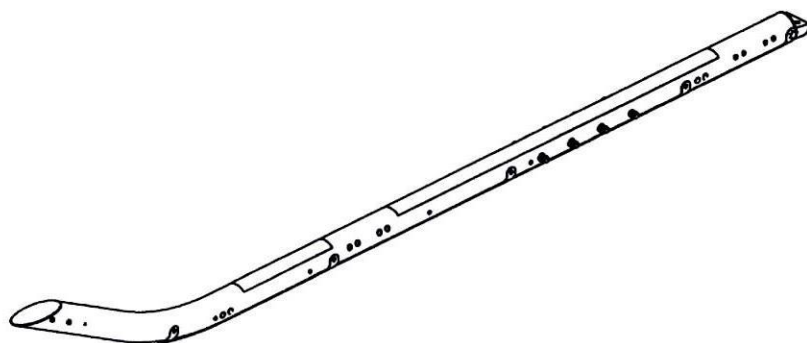
SHOP CO.
RETURN TO
ENGINEERING
UNCONTROLLED CO
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 167339-4
OCT 27 2017

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2013-08-13
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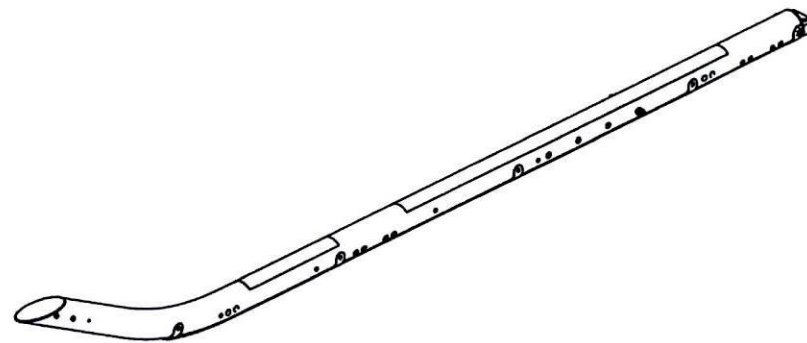
B	ADD VIEW TO CONTROL FWD BEND ORIENTATION (2N D-1-4/-5/-6/-7); UPDATED FINISH OPTIONS. REASON: PAR13-276 AND NCR13-2757	MB	13.07.11
A	NEW ISSUE	SC	10.08.09
REV.	DESCRIPTION	BY	DATE
DESIGN	SC		
DRAWN	JP		
CHECKED	JP		
MFG. APPR.	JP		
APPROVED	JP		
DE APPR.	JP		
DATE	13.07.11		

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DRAWING NO. D4168	REV. B
TITLE 350 SKIDTUBE ASSEMBLY	SHEET 1 OF 11
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D4168-043 350 SKIDTUBE ASSEMBLY, LH

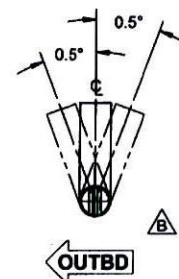


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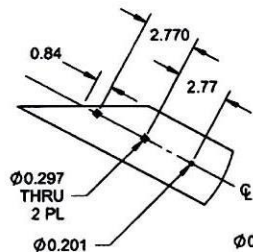
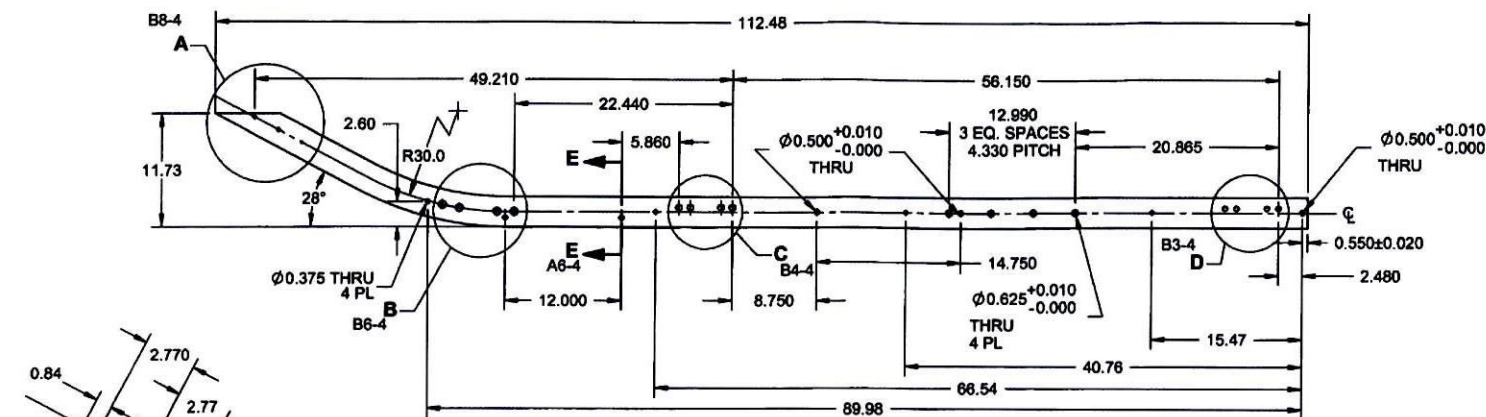
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CHECKED		DRAWING NO. D4168	REV. B
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DE APPR.			NTS
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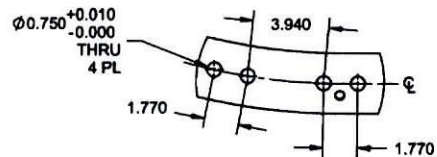
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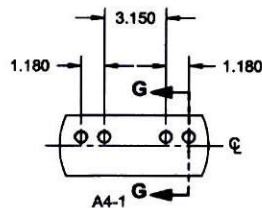
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TWIST ON FWD BEND
(VIEWED LOOKING FWD)



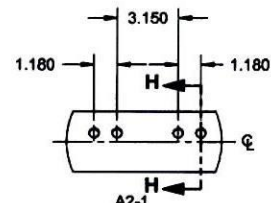
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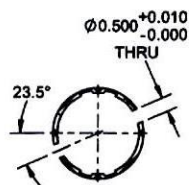
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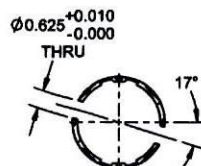
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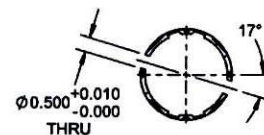
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D6-4



B4-4



B2-4

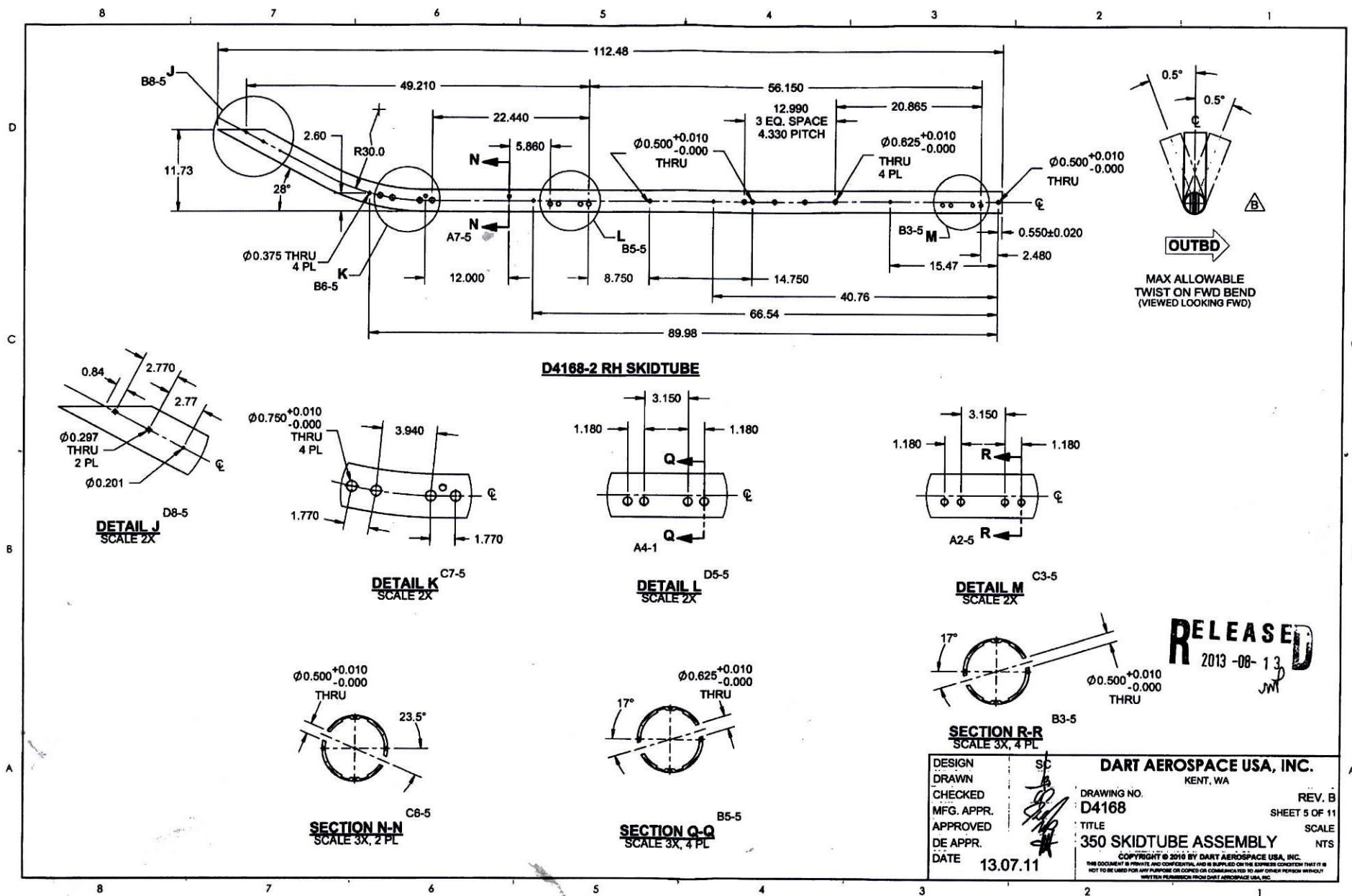
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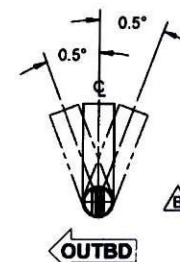
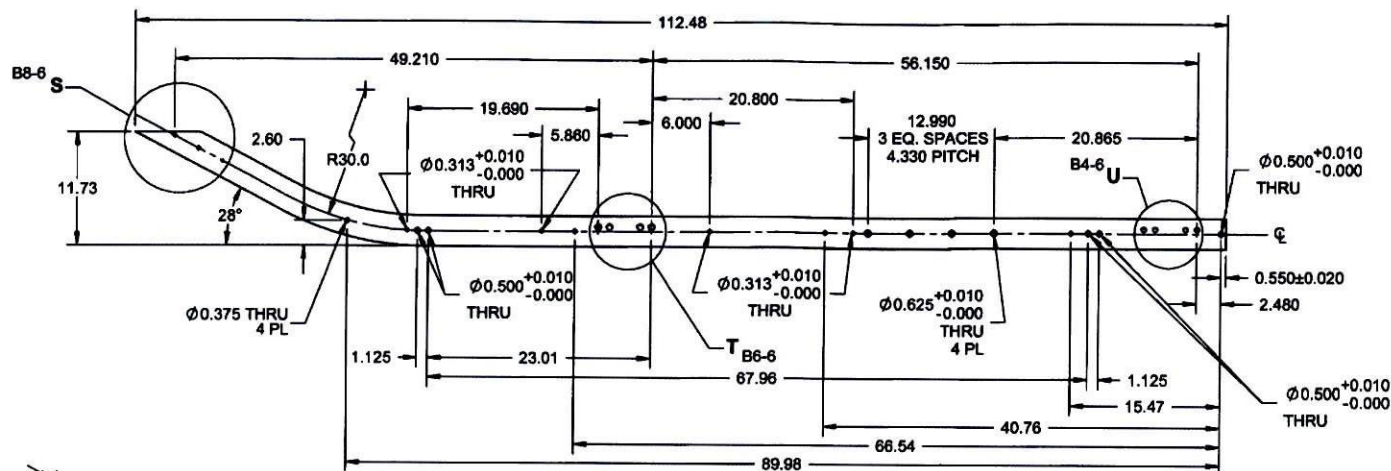
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350 SKIDTUBE ASSEMBLY
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SHEET 4 OF 11
SCALE
NTS

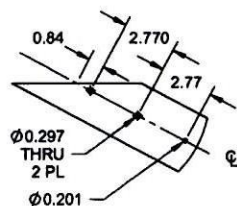
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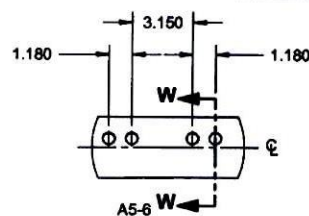




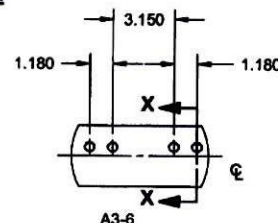
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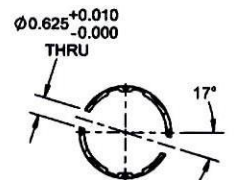
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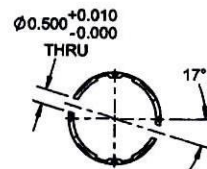
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DETAIL U
SCALE 2X



SECTION W-W
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SECTION X-X
SCALE 3X, 4 PL

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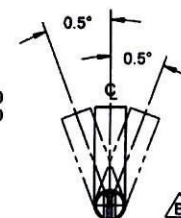
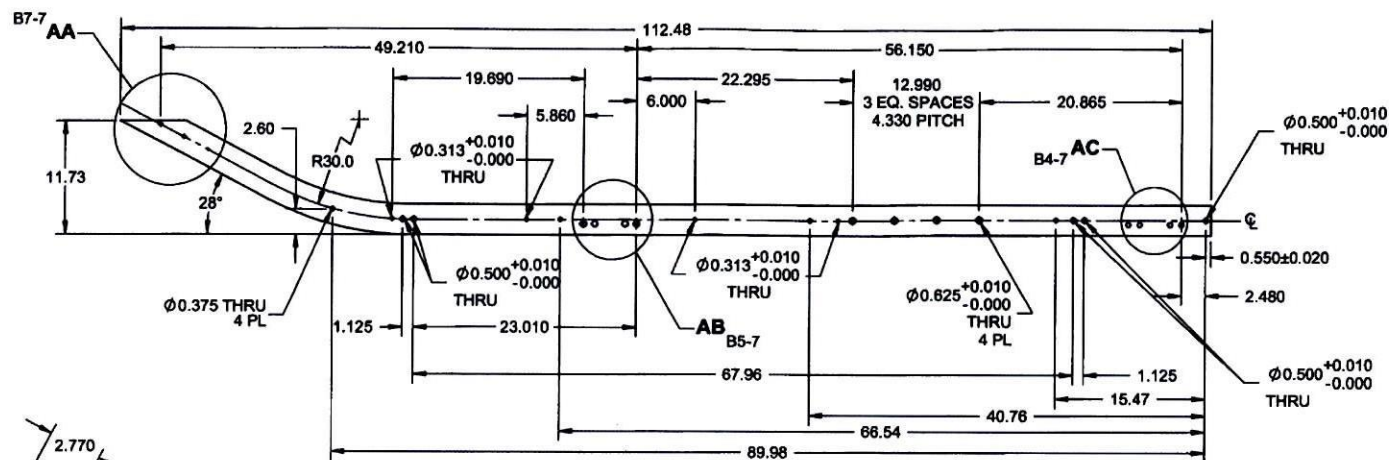
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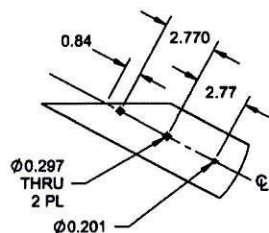
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TITLE
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SHEET 6 OF 11
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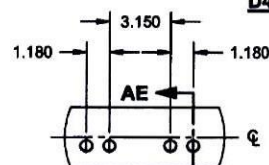
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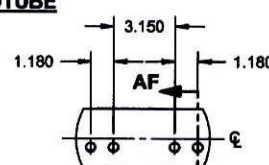
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TWIST ON FWD BEND
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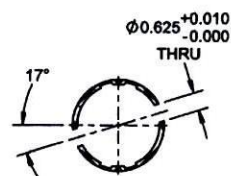
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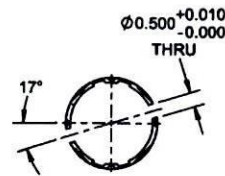
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SCALE 2X



DETAIL AC
SCALE 2X



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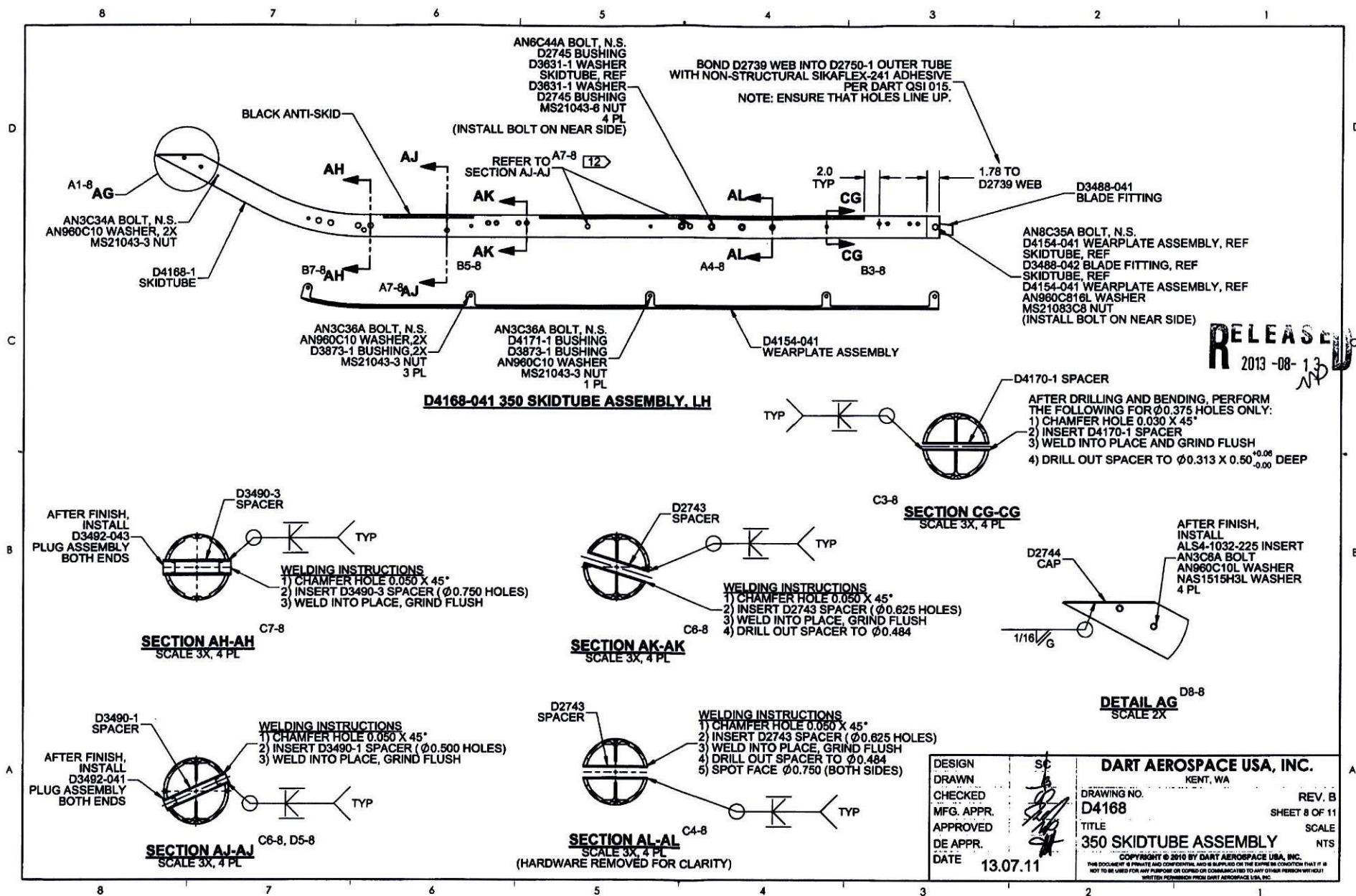


SECTION AF-AF
SCALE 3X, 4 PL

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2013-08-13

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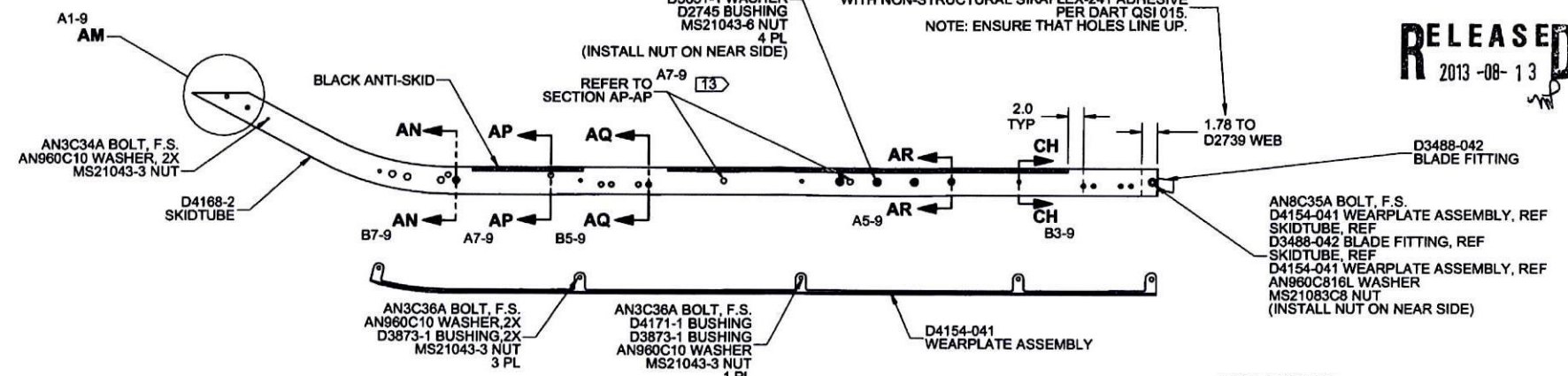
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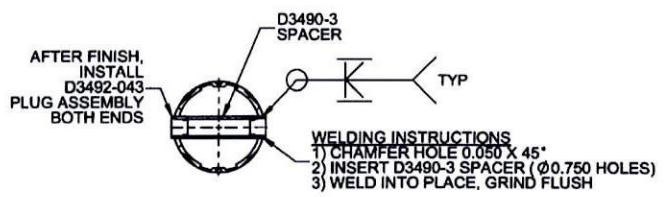
RELEASED
2013-08-13

AN8C44A BOLT, F.S.
D2745 BUSHING
D3631-1 WASHER
SKIDTUBE, REF
D3631-1 WASHER
D2745 BUSHING
MS21043-6 NUT
4 PL
(INSTALL NUT ON NEAR SIDE)

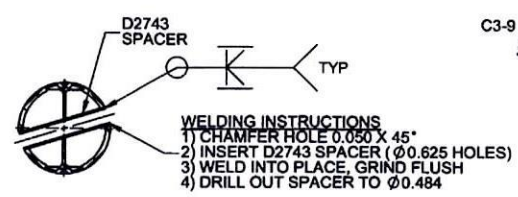
BOND D2739 WEB INTO D2750-2 OUTER TUBE
WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE
PER DART QSI 015.
NOTE: ENSURE THAT HOLES LINE UP.



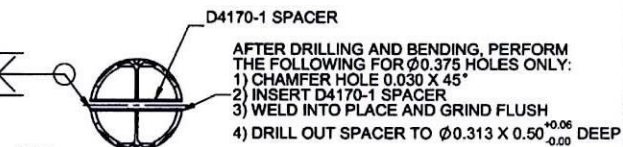
D4168-042 350 SKIDTUBE ASSEMBLY, RH



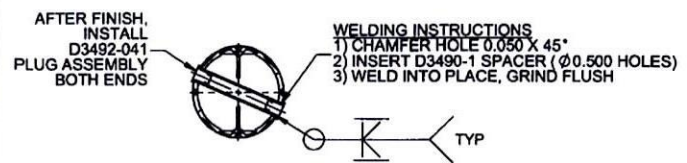
SECTION AN-AN
SCALE 3X, 4 PL



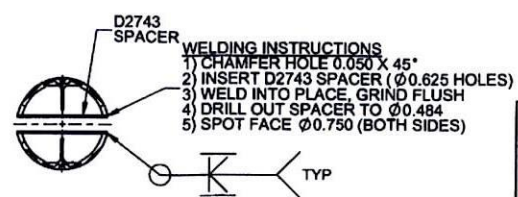
SECTION AQ-AQ
SCALE 3X, 4 PL



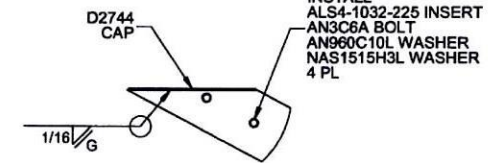
SECTION CH-CH
SCALE 3X, 4 PL



SECTION AP-AP
SCALE 3X, 4 PL

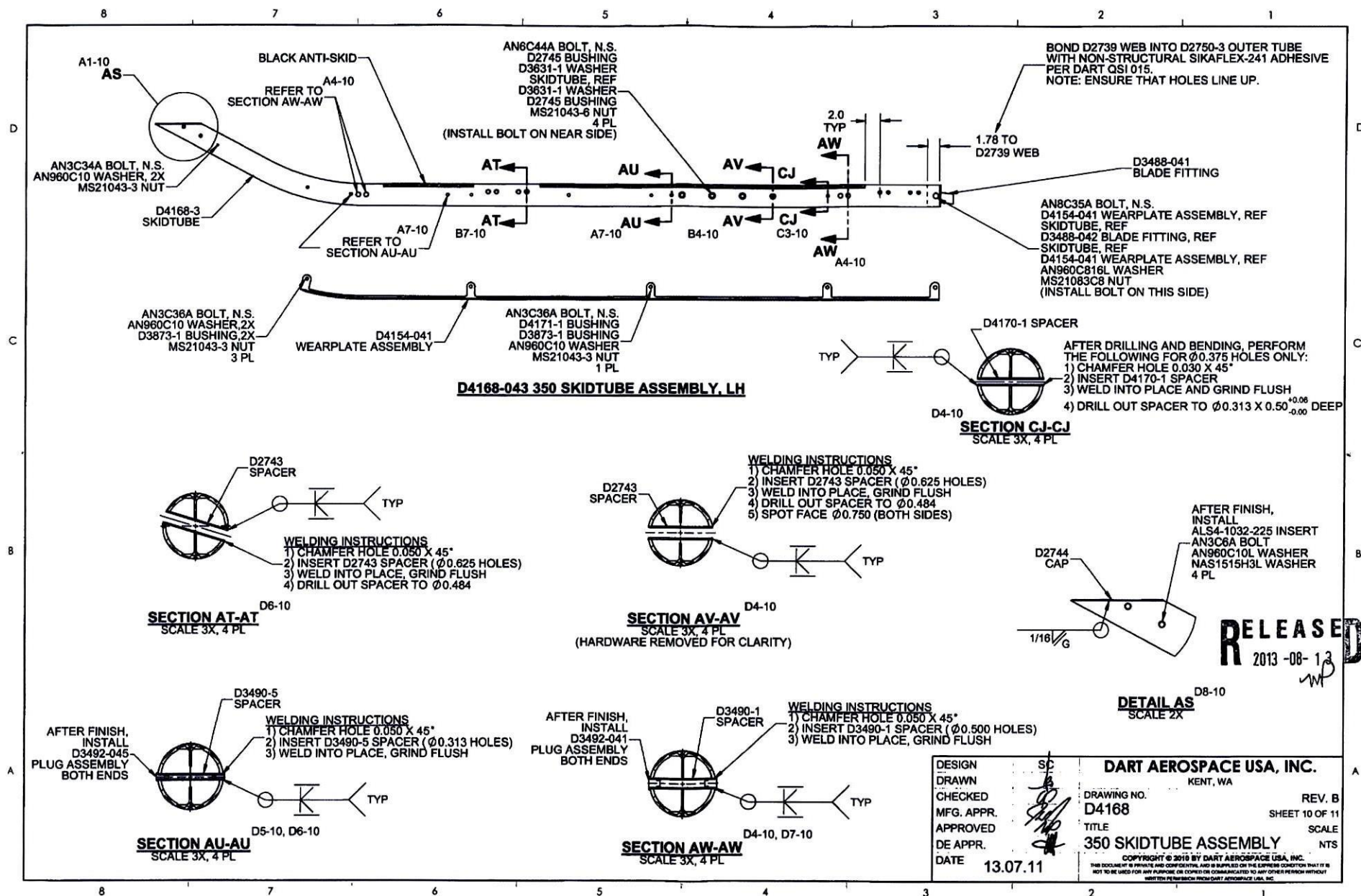


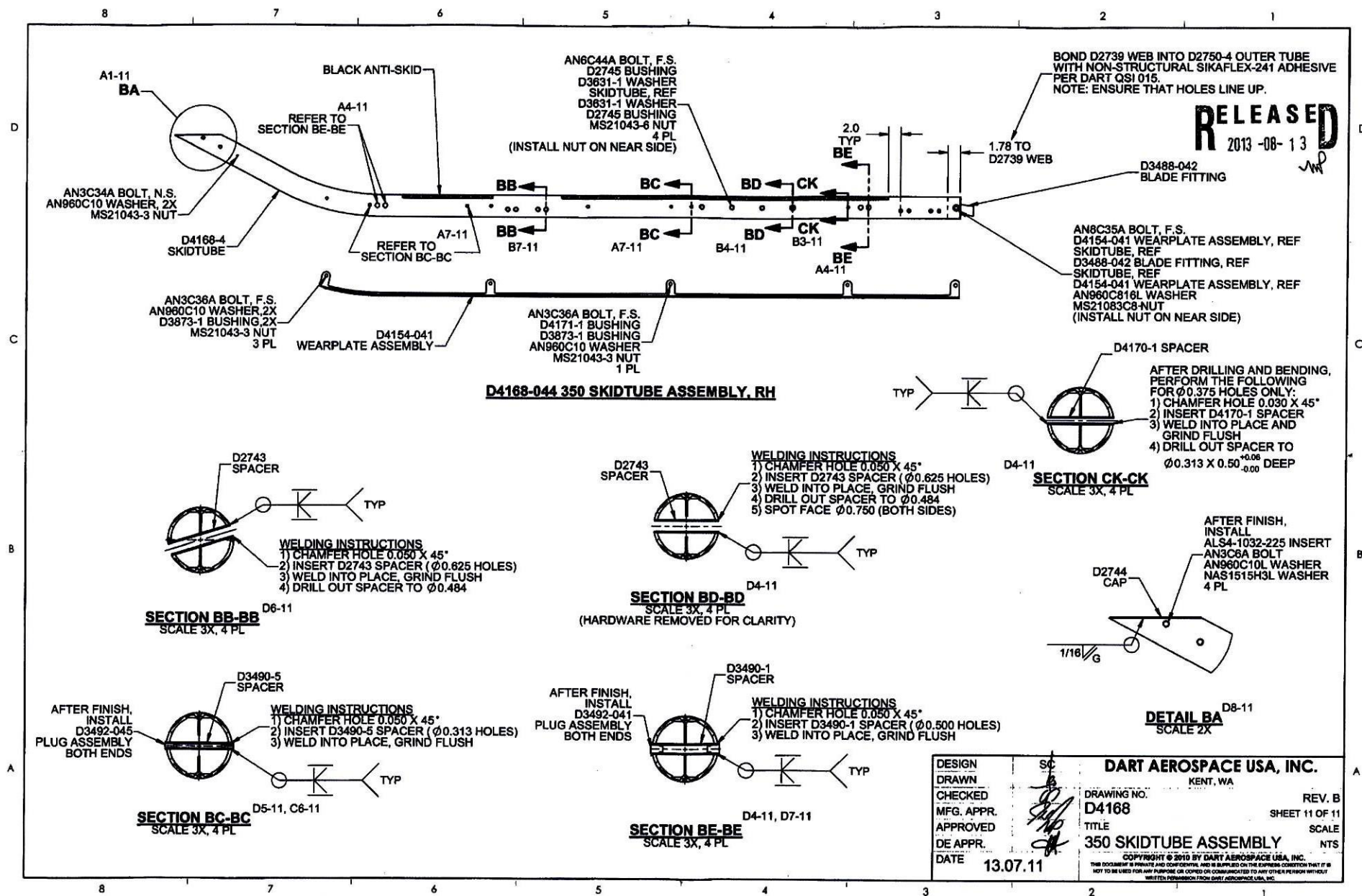
SECTION AR-AR
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



DETAIL AM
SCALE 2X

DESIGN DRAWN CHECKED MFG. APPR. APPROVED DE APPR. DATE	SC 13.07.11	DART AEROSPACE USA, INC. KENT, WA DRAWING NO. D4168 TITLE 350 SKIDTUBE ASSEMBLY REV. B SHEET 9 OF 11 SCALE NTS COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRELIMINARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR REPRODUCTION OR COMMUNICATION TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.
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K6A 1K7
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Master Unit 000473

Tel (613) 632-5200

Containers on Master Unit 000473				
Serial No	Part No	Customer Part No	Status	Quantity
S038760	AN3C37A		Allocated	1
S038759	AN3C42A		Allocated	1
S038758	AN8C21A	AN8C21A	Allocated	2
S038757	D2741	D2741	Allocated	1
S038756	D3493-1		Allocated	2
S038749	MS21083C8	MS21083C8	Allocated	2
S038748	NAS1149D0863J	NAS1149D0863J	Allocated	2